

9

Date: Thursday, 1/17/2008 3:25:30 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: 212 BASKET BASE ASS'Y RH		
Job Number	: 36820B			Part Number	: D3053042		
Estimate Number	: 11543			Drawing Number	: D3053 REV A		
P.O. Number	:			Project Number	:		
This Issue	: 1/17/2008 S.O. No. :			Drawing Revision	: A		
Prsht Rev.	: NC			Material	:		
First Issue	: / / Type : LARGE FAB ASSY			Due Date	: 2/24/2008 Qty: 1 Um: Each		
Previous Run	: 29378B						
Written By	: <u>KJF 01-18</u>						
Checked & Approved By	:						
Comment	: Est. C 02.09.04 M304EX0.75-16F was M750-16FXS-S/SK J/RF						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304TS0750W065	304 SQ Tube.75x.75x.065W	
		Comment: Qty.: 45.5000 f(s)/Unit Total : 45.5000 f(s) 304 SQ Tube.75x.75x.065W Cut Rib from 3/4" x 3/4" x 0.063 wall 304/316 SS tubing.	Batch: <u>M107814 FC 08 04 14</u>
2.0	D31661	Basket Hoop	
		Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s) Basket Hoop Qty. 5 D3166-1 Batch: <u>D37611</u>	<u>FC 08 04 14</u>
3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	
		Comment: LARGE FABRICATION RESOURCE 1 Cut 5 D2235-3 FROM D3166-1  Drill holes in D3053-3 as per Dwg D3053	<u>FC 08 04 14</u>
4.0	D23273	Spacer Bushing	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Spacer Bushing Pick: Qty Part Number Description Batch 2 D2327-3 Bushing <u>b36479</u>	<u>FC 08 04 14</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: 212 BASKET BASE ASS'Y RH
Job Number: 36820B		Part Number: D3053042
Job Number:		
Seq. #:	Machine Or Operation:	Description :
5.0	D22323 	Basket Hinge 
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Basket Hinge Pick: Qty Part Number Description Batch 2 D2232-3 Hinge plate <u>136846</u>		FC 08 04 14
6.0	D2581 	Mounting Bracket 
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Mounting Bracket Pick: Qty Part Number Description Batch 2 D2581 Mounting Bracket <u>M37248</u>		FC 08 04 14
7.0	M304EX07516F 	Expanded Metal Flat Stai 
Comment: Qty.: 50.4000 sf(s)/Unit Total : 50.4000 sf(s) Expanded Metal Flat Stai Pick: Qty Part Number Description Batch 48sq.ft M304EX0.75-16F Expanded Metal <u>M107511</u>		FC 08 04 14
8.0	LARGE FAB 1 	LARGE FABRICATION RESOURCE 1   
Comment: LARGE FABRICATION RESOURCE 1 Remove all markings from material Drill holes in three D2235-3 ribs as per Dwg D3053 using Jig DT8365  Weld as per Dwg D3053 using Welding Table and corner Jig Deburr as required		FC 08/04/15
9.0	QC9 	VISUAL WELDING INSPECTION 
Comment: VISUAL WELDING INSPECTION		RD 08-04-16 ①
10.0	QC6 	DIMENSIONAL CHECK 
Comment: DIMENSIONAL CHECK		RD 08-04-16 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3053-042 PAR #: N/A Fault Category: Prod/Large NCR:  Yes No DQA:  Date: 08/04/23  
 QA: N/C Closed:  Date: 08/04/23

NCR: 36820B		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/04/11	8.0	Employee <del>xx</del> Drilled D2235-3 X1 using the old drill jig DT 8365, needed to use DT 8995. Old jig is not perfectly centered.	J 08/04/11	P.H holes w/1L weld AS per QSI004, and grind flush. drill new holes AS per drawing. Identify DT 8365 To not use drill holes, and block drill holes.	FC 08/04/11	QC9 PD 08-04-11	J 08/04/11	J 08-04-11

NOTE: Date & initial all entries

Date: Thursday, 1/17/2008 3:25:30 PM  
User: Kim Johnston

## Process Sheet

30 min.  
18/04/2008  
S.062 09.38  
#1 403.9 F  
D.3053042  
B.36820B

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: 212 BASKET BASE ASS'Y RH
Job Number: 36820B		Part Number: D3053042
Job Number:		
Seq. #:	Machine Or Operation:	Description :
11.0	DC	DOCUMENT CONTROL 
12.0	POWDER COATING	POWDER COATING Pressure wash <i>Fx 08/04/18</i>  <i>M 107550</i>
13.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION  <i>M 1 08/04/18</i>
14.0	PACKAGING 1	PACKAGING RESOURCE #1  <i>Identify and Stock Location: PPP 36820 08/04/18</i>
15.0	QC21	FINAL INSPECTION/W/O RELEASE  <i>08/04/23</i>
Comment: FINAL INSPECTION/W/O RELEASE		
Job Completion		 <i>mr = 08-04-22</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

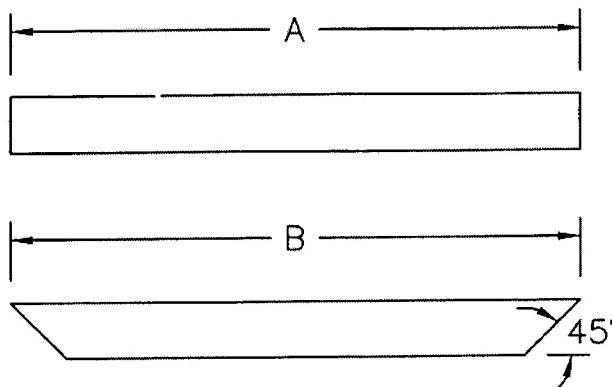
NOTE: Date & initial all entries

ISSUED  
COPY

DESIGN <i>RF</i>	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3053	REV. A	SHEET 1 OF 3
DATE 01.11.01	TITLE BASKET BASE ASSEMBLY (212)			SCALE NTS
A	01.11.01	NEW ISSUE		

RELEASED  
01.12.20 *[Signature]*PARTS LIST FOR D3053-041/D3053-042 BASKET BASE ASSEMBLY

PART NO	QUANTITY	LENGTH A.	LENGTH B	DESCRIPTION
D3053-1	2	—	96.00	RIB
D3053-3	2	—	25.50	RIB
D3053-5	6	23.73	—	RIB
D3053-7	3	25.31	—	RIB
D3053-9	3	19.48	—	RIB
D2327-3	2	N/A	N/A	BUSHING
D2581	2	N/A	N/A	MOUNTING BRKT
D2232-3	2	N/A	N/A	HINGE PLATE
D2235-3	5	N/A	N/A	RIB



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WITHOUT NOTICE  
WORK ORDER  
NO 368203

NOTES:

- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) FRAME MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.060 WALL SQUARE TUBING
- 3) MESH MATERIAL: 3/4-16F EXPANDED SS
- 4) WELD PER DART QSI 004
- 5) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES

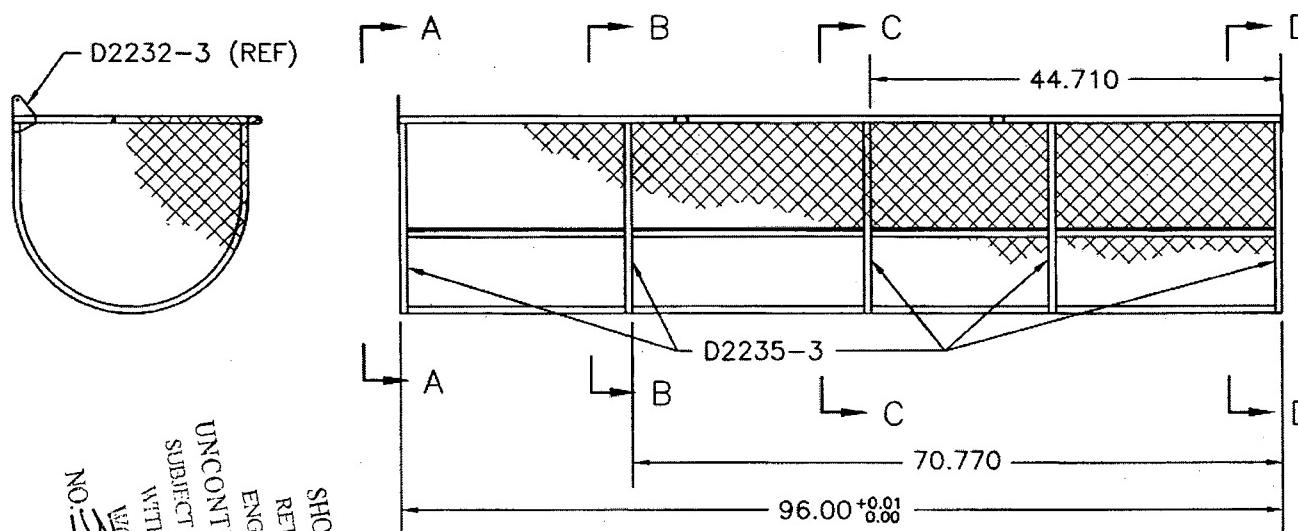
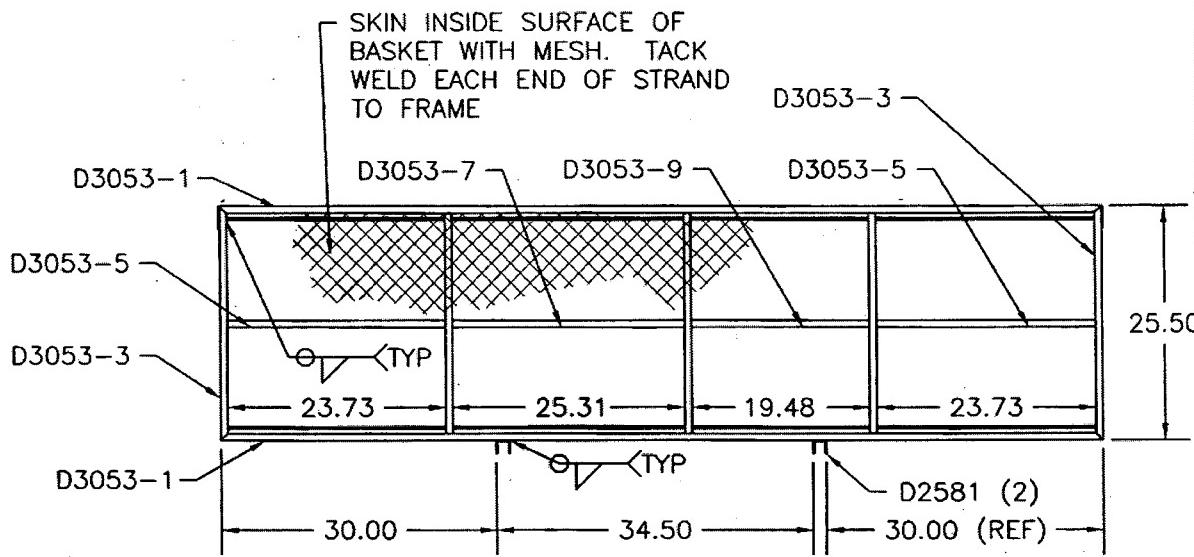
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3053
DATE 01.11.01	TITLE BASKET BASE ASSEMBLY (212)	REV. A SHEET 2 OF 3 SCALE 1:20

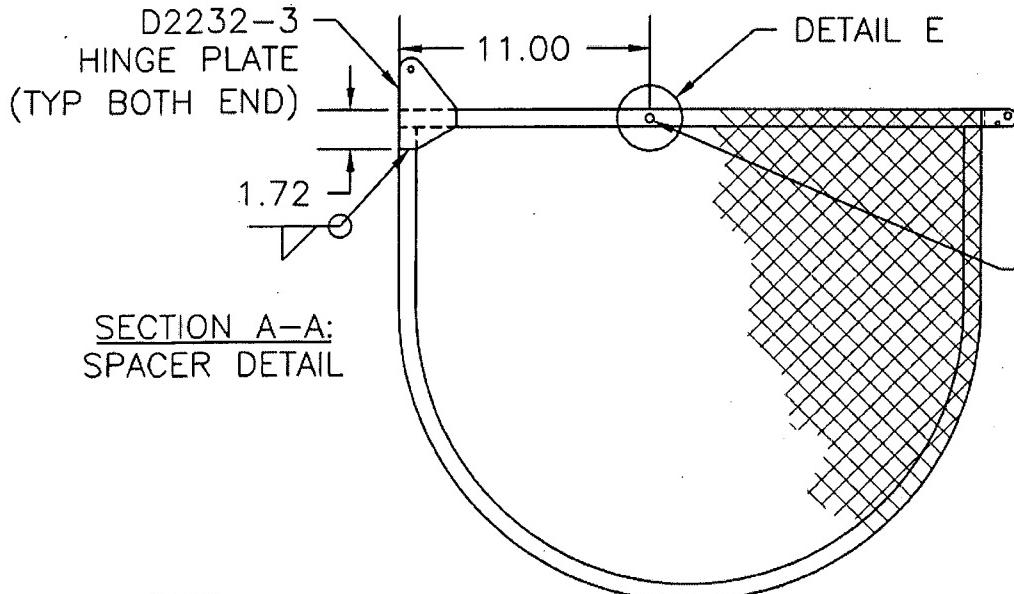
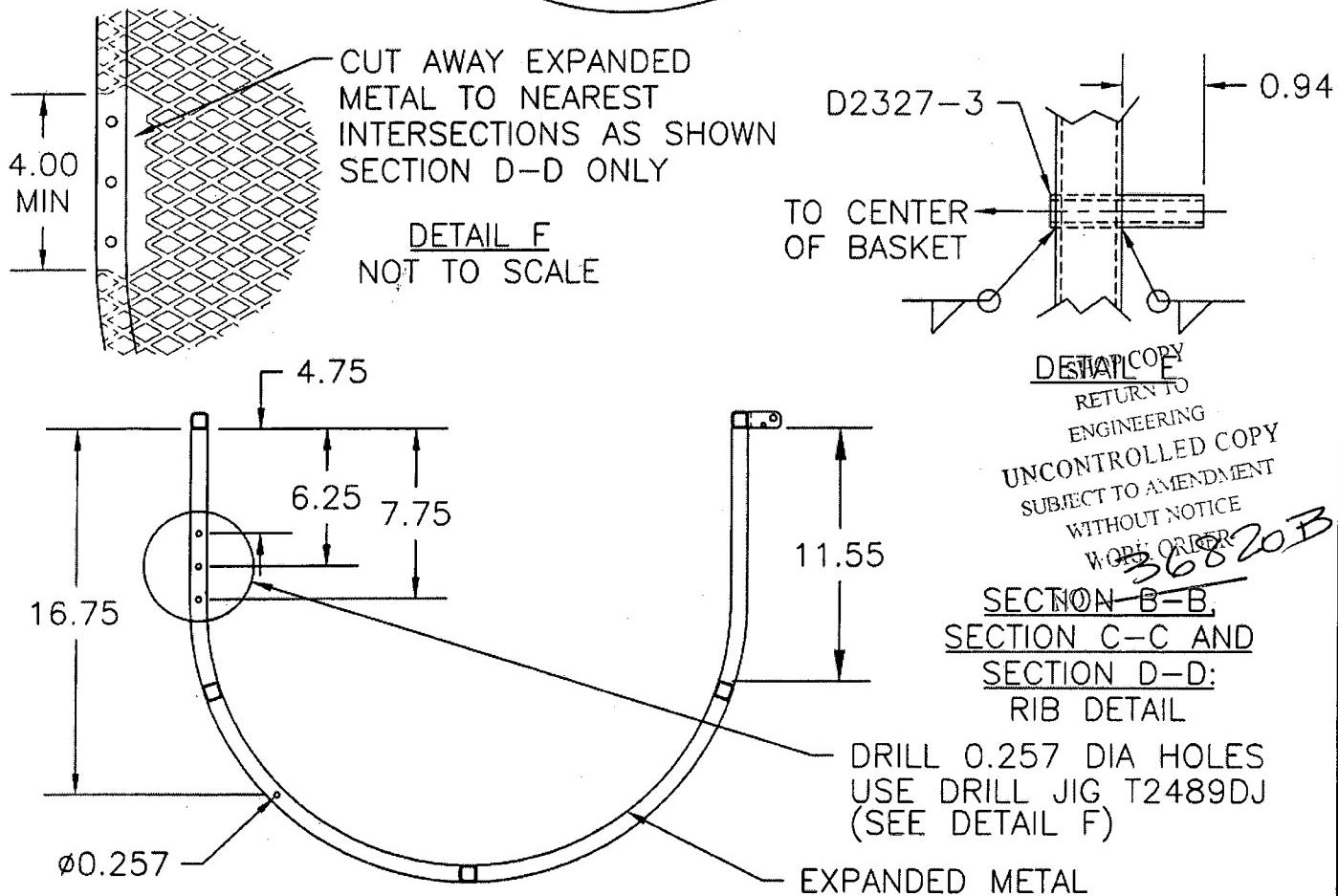


D3053-042 BASKET BASE ASSEMBLY SHOWN  
(D3053-041 BASKET BASE ASSEMBLY OPPOSITE)

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3053	REV. A SHEET 3 OF 3
DATE 01.11.01		TITLE BASKET BASE ASSEMBLY (212)	SCALE 1:8

**RELEASED**  
01.12.20 #

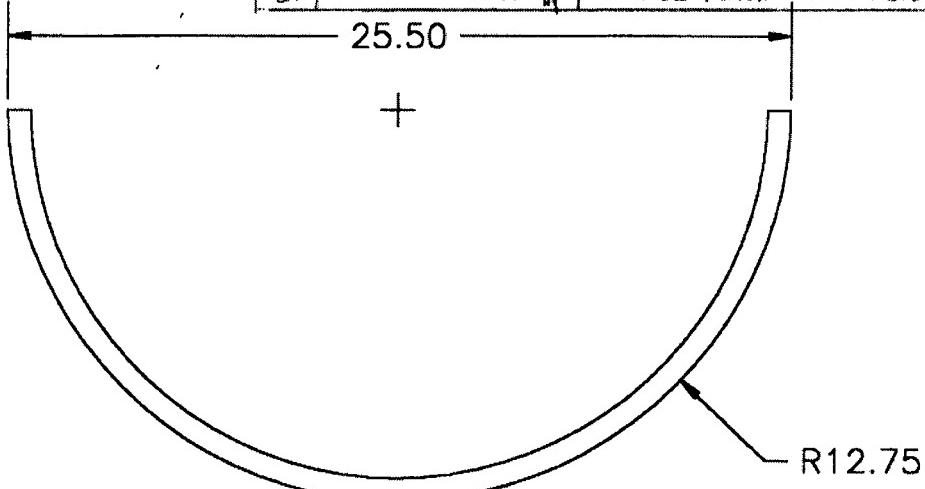
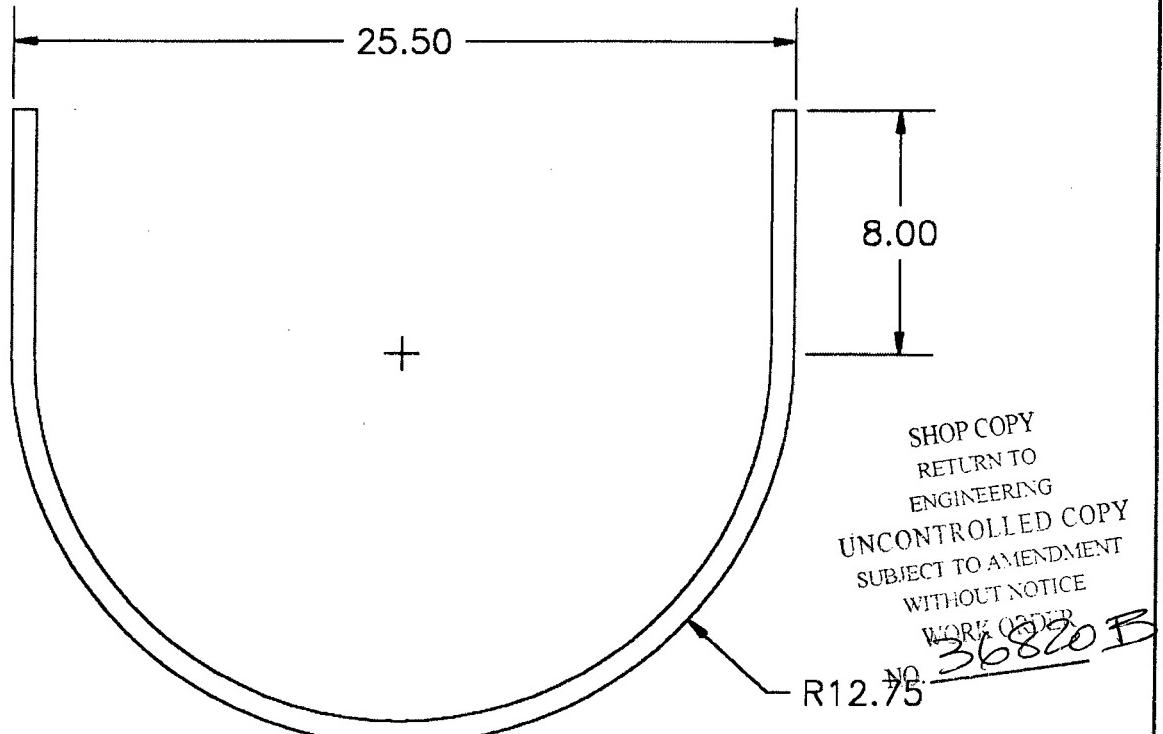
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**DART**

DESIGN B WILLIAMS	DRAWN BY B WILLIAMS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>BW</i>	APPROVED <i>BW</i>	DRAWING NO. D2235	REV. B SHEET 1 OF 1
DATE 94-12-16		TITLE BASKET RIBS	SCALE

B1 02.08.06 (A) CAN BE MADE FROM D3166-1

**RELEASED**  
R 960507D2235-1D2235-3

CAN BE MADE FROM D3166-1 (B)  
MATERIAL: 304/316 SS, 3/4 X 3/4 X 0.063 WALL SQR.